











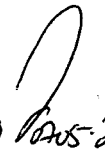



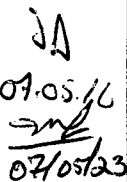

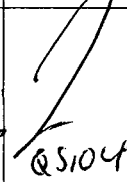
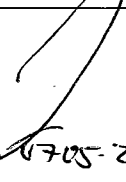
Date: Tuesday, 15/05/2007 3:25:20 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 31942	
Estimate Number : 11169	
P.O. Number : N/A	Part Number : D32831
This Issue : 15/05/2007 S.O. No. : N/A	Drawing Number : D3283 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 17/04/2007 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 25339	Material : N/A
Written By : _____	Due Date : 24/04/2007 Qty: 20 Um: Each
Checked & Approved By : _____	
Comment : Est A 04.09.28 New issue KJ/JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M6061T6S063 6061-T6 .063 Sheet
	
	
Comment: Qty.: 0.2479 sf(s)/Unit Total : 4.9581 sf(s) 6061-T6 .063 Sheet Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3283-1 Batch: M19326	
2.0	SHEAR SHEAR
	
	
Comment: SHEAR Cut blanks: 15.550" x 1.540"	
3.0	HAAS1 HAAS CNC VERTICAL MACHINING #1
	
	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA424 and Dwg D3283 Stack of 10 Identify as D3283-1	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8 SECOND CHECK
	
	
Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Add etch & alodine per Dwg DS2P3 & QS1065 <u>Perm. chg.</u>	EE	07.05.28		 070528	 070528

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.05.16	5.0	-drawing shows 57 holes but only 56 are drilled. -part matches with float webs	 QS1042	Drill hole manually & deburr. See PAR 179.	 07.05.16 07/05/23	 07.05.23	 QS1042	 07.05.23

NOTE: Date & initial all entries

Date: Tuesday, 15/05/2007 3:25:20 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31942

Part Number: D32831

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

X20
ml 07/05/28

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SPB 07/05/28 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

PC 7/6/04 (20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20)
07/06/04

Job Completion



u 07-06-04



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN CP		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D3283	
DATE 05.08.09		TITLE DOUBLER		REV. D SHEET 1 OF 2	
A		04.05.06		NEW ISSUE	
B		04.08.09		10.882 WAS 11.502	
C		05.03.16		CHANGE HOLE PATTERN FOR -1	
D		05.08.09		REDESIGN	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

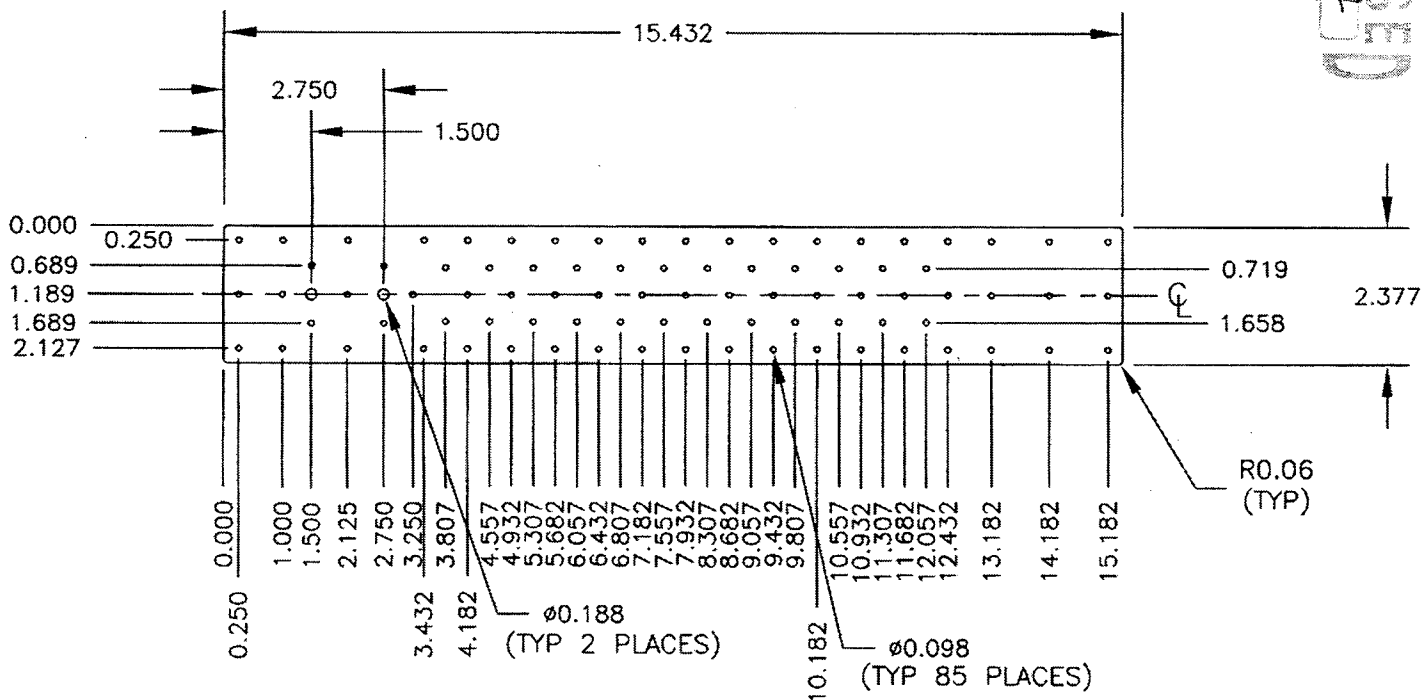
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3283	REV. 0
		TITLE	DOUBLER	SHEET 2 OF 2
		SCALE	1:3	



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

675 FIRST ARTICLE INSPECTION CHECKLIST

<input checked="checked" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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Measured by:	<i>SA</i>	Audited by:	<i>En</i>	Prototype Approval:	
Date:	<i>07-03-13</i>	Date:	<i>07/05/15</i>	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revD